

12/2009 4:27:59 PM

IX

Process Sheet

R001 Dart Helicopters Services

Drawing Name : AFT BLADE FOLD ASSEMBLY

13532

Issue

: 09/02/2009

S.O. No. :

Prsht Rev.

: NC

First Issue

: / /

Type : SMALL /MED FAB

Previous Run

: 45645

Written By

:

Checked & Approved By

:

Comment

: Est Rev:A 08-07-30 new issue DD verified by:ec

Est Rev:B 08-12-04 up date part list DD Verified by:ec

Part Number

: PB674300103

Drawing Number

: B6743001 P.1,3,4,15

Project Number

: N/A

Drawing Revision

: B1

Material

:

Due Date

: 01/04/2009

Qty:

1 Um:

Each

Additional Product

MEL PARTS NOT Scanned

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PB674300109

Aft Blade Fold Assembly Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Blade Fold Assembly Weldment

batch: 45047

UMF 09-03-11

2.0

PB674300113

Aft Adjustable Blade Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Adjustable Blade Support Assembly

batch: 45042

UMF 09-03-11

3.0

PB674300117

Aft Adjustable Blade Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Adjustable Blade Support Assembly

batch: 45040

UMF 09-03-11

4.0

PB674300121

PB67-43001-21



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PB67-43001-21

batch: B45038

UMF 09-03-11

5.0

PB674300123

PB67-43001-23



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PB67-43001-23

batch: B45035

UMF 09-03-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:27:59 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45646

Part Number: PB674300103

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	PB674300137	PB67-43001-37
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PB67-43001-37

batch: 45029

CPL 09-03-12

7.0	PB674300157	Stabilizer Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Stabilizer Arm

batch: 45028

CPL 09-03-12

8.0	PB674300159	PB67-43001-59
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PB67-43001-59

batch: 45024

CPL 09-03-12

9.0	PB674300163	Handle Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Assembly

batch: 45023

CMF 09-03-11

10.0	PB6743001135	Male Eye
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Male Eye

batch: 23995A

CMF 09-03-11

11.0	PB6743001155	Pin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pin

batch: B43092

CMF 09-03-11

12.0	PB6743001261	Lever Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Lever Arm

batch: 43093

CMF 09-03-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:27:59 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45646

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PB6743001265

Bushing



Comment: Qty.: 5 4.0000 Each(s)/Unit Total : 5 4.0000 Each(s)

Bushing

batch: 41375 44977

lpl09.03.12

14.0

PB6743001299

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

batch: 40062

lpl09.03.12

15.0

PB6743001305

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bearing

batch: 41886

lpl09.03.12

16.0

D3451045

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle and Lock-Down Assembly

batch: 45309

lpl09.03.12

17.0

D3451043

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle and Lock-Down Assembly

batch: 45308

lpl09.03.12

18.0

D34401

Tube Guide (Supersedes B67-43001-25/-307)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tube Guide

batch: 41347

lpl09.03.12

19.0

D34403

Clamp (Supersedes B67-43001-309)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Clamp

batch: 41277

lpl09.03.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:27:59 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45646

Part Number: PB674300103

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	D34441	Velcro Loop Belt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Velcro Loop Belt
batch: 39965

lpl09.03.12

21.0	D34491	Pad
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pad
batch: 45287

lpl09.03.12

22.0	D34479	Swing Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Swing Arm
batch: 41352

lpl09.03.12

23.0	086004	Inventory
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Inventory
batch: m109350

lpl09.03.12

24.0	MS27039107	Screw
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Screw
batch: m18057

lpl09.03.12

25.0	MS27039123	SCREW
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
SCREW
batch: m18057

lpl09.03.12

26.0	MS21042L4	Nut
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Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Nut
batch: m109282

lpl09.03.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:27:59 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45646

Part Number: PB674300103

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	MS21042L6	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: m108183

lpl09.03.12

28.0	MS518596	WASHER
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: m108986

lpl09.03.12

29.0	MS518598	WASHER
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: m108986

lpl09.03.12

30.0	NAS43DD368	SPACER
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SPACER

batch: m109060

lpl09.03.12

31.0	NAS1149F0316P	WASHER
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

batch: m111117

lpl09.03.12

32.0	NAS1149F0432P	Washer
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

batch: m18057

lpl09.03.12

33.0	NAS1149F0632P	WASHER
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: 18057

lpl09.03.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:27:59 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45646

Part Number: PB674300103

Job Number:



Seq. #:	Machine Or Operation:	Description :
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34.0	NAS1149F0832P	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

batch: 18054

Cpl 09.03.12

35.0	AN960JD6	Washer
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Comment: Qty.: 5 1.0000 Each(s)/Unit Total : 5 1.0000 Each(s)

Washer

batch: M6085

Cpl 09.03.12

36.0	AN410A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M107178

Cpl 09.03.12

37.0	AN413A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

batch: M110865

Cpl 09.03.12

38.0	AN415A <u>15A</u>	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: M110399

or AN415A (see engineering) batch: M110399

Cpl 09.03.12

39.0	AN611A	BOLT
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

batch: M105558

Cpl 09.03.12

40.0	AN620A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M11119

or AN6116A (see engineering) batch: M11119

Cpl 09.03.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:27:59 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45646

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

batch: m108480

P/L 09-03-12

42.0

BSP43

RIVET



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

RIVET

batch: m109119

P/L 09-03-12

43.0

CR3213405

cherry rivet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

cherry rivet

batch: m104214

P/L 09-03-12

44.0

MS17984C413

PIN, QUICK RELEASE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PIN, QUICK RELEASE

batch: _____

or MS17984C410 (see engineering) batch: m109739

P/L 09-03-12

45.0

MS17984C418

PIN, QUICK RELEASE



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

PIN, QUICK RELEASE

batch: m108986 x 3

P/L 09-03-12

46.0

30345T21

LANYARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

LANYARD

batch: ~~17828~~ m102812

P/L 09-03-12

47.0

30345T24

LANYARDS



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

LANYARDS

batch: m108973

P/L 09-03-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/03/2009 1:15:17 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT BLADE FOLD ASSEMBLY
Job Number :	45646		
Estimate Number :	13532		
P.O. Number :		Part Number :	PB674300103
This Issue :	10/03/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.1,3,4,15
First Issue :	09/02/2009	Project Number :	N/A
Previous Run :	45645	Drawing Revision :	B1
	Type :	Material :	
	SMALL /MED FAB	Due Date :	01/04/2009
Written By :		Qty:	1
Checked & Approved By :	<u>MF 09-03-10</u>	Um:	Each
Comment :	Est Rev:A 08-07-30 new issue DD verified by:ec		
	Est Rev:B 08-12-04 up date part list DD Verified by:ec		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

50.0

MS24694S102

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

m14604

Cpl 09.03.12

51.0

MS518597

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

m106421

Cpl 09.03.12

52.0

AN526A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

m18057

Cpl 09.03.12

53.0

NAS1149F0532P

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

m18057

Cpl 09.03.12

54.0

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Nut

m110382

Cpl 09.03.12

Job Completion



Date: Monday, 09/02/2009 4:27:59 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSEMBLY

Job Number: 45646

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

SPRING SLOTTED PIN

batch: 111088 x11

Plc 09.03.12

49.0

3408A98

DETENT BALL SPRING PLUNG



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

DETENT BALL SPRING PLUNG

batch: M 111678

Plc 09.03.12

50.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK batch:

N A - look at other page MF 09-03-12

51.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09.03.12 (1)

52.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PMD 4.5605 Plc 9/3/12

53.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(1) 09/03/13 MF 09-03-13

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/03/2009 12:48:40 PM
User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT BLADE FOLD ASSEMBLY
Job Number	: 45646		
Estimate Number	: 13532		
P.O. Number	:	Part Number	: PB674300103
This Issue	: 11/03/2009 S.O. No. :	Drawing Number	: B6743001 P.1,3,4,15
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 09/02/2009 Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	: 45645	Material	:
Written By	:	Due Date	: 01/04/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>mf 09-03-11</u>		
Comment	: Est Rev:A 08-07-30 new issue DD verified by:ec Est Rev:B 08-12-04 up date part list DD Verified by:ec		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

55.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK batch: M10969709-03-12

Job Completion

